

Date: Monday, 05/05/2008 2:31:02 PM
User: Melanie Fauteux

Process Sheet

ASAP 10

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ANGLE
Job Number : 39053
Estimate Number : 13169
P.O. Number : Part Number : D37301
This Issue : 05/05/2008 S.O. No. : Drawing Number : D3730 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : MACHINED PARTS Drawing Revision :
Previous Run : 38600 Material :
Due Date : 12/05/2008 Qty: 20 Um: Each
Written By :
Checked & Approved By : *mf*
Comment : Est Rev:A 08-01-30 new issue DD verified by:
Est Rev:B 08-03-19 chg to revB ecn 1158 DD verified by:

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6A750W125 angle 750 x 750 x.125w



Comment: Qty.: 0.1749 f(s)/Unit Total: 3.4986 f(s)
D6207 angle extrusion
Batch: *M18147*

MA 08/05/06

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut to Length as per Dwg D3730

mf / H.A 08/05/06

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: 1- drill holes as per dwg D3730

2-Deburr

mf / H.A 08/05/06

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mf / H.A 08/05/06

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/05/06 (+20)

Process Sheet

Drawing Name: ANGLE

Part Number: D37301

Abstract

Description :

SMALL & MEDIUM FAB RESOURCE 1

~~2/08/06~~ ~~stop~~ ~~and~~ 08/05/06 (28)

2- Deburr if necessary

INSPECT WORK TO CURRENT STEP

008/0502 120

HAND FINISHING RESOURCE #1

08.05.07

Chemical Conversion Coat as per QSI 005 4.1

INSPECT POWDER COAT/CHEMICAL CONVERSION

08/05/07 020

PACKAGING RESOURCE #1

08.05.0720

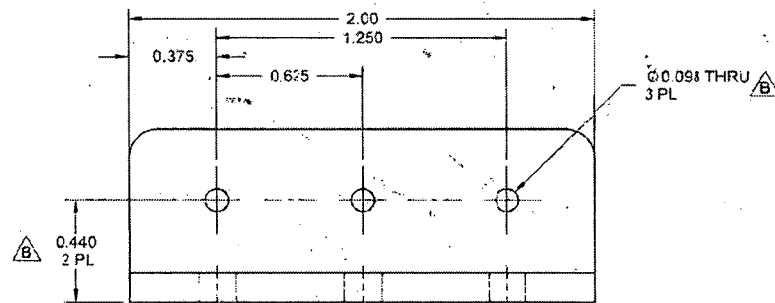
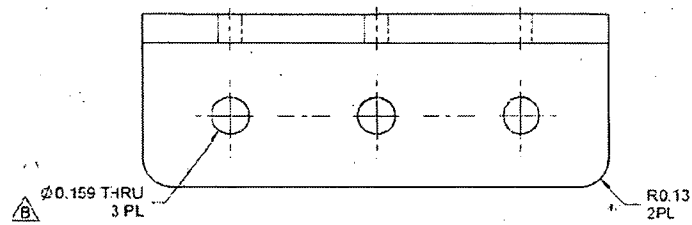
Identify and Stock
Location: *W17*

FINAL INSPECTION/W/O RELEASE

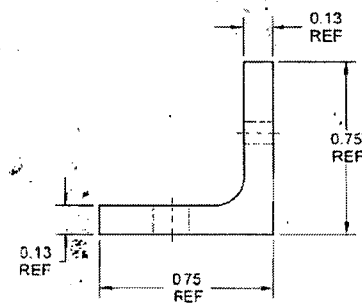
08/05/08

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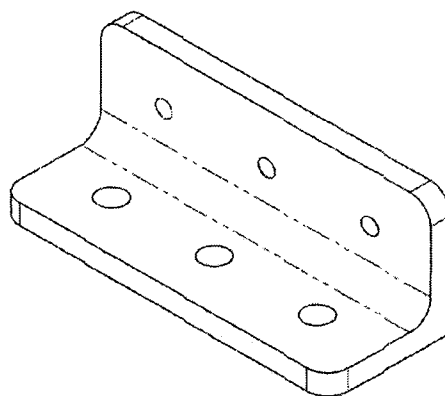
MF 08-05-07



D3730-1 ANGLE



DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	IS	D3730	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ANGLE	NTS
DATE	08.03.06	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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D3730-1 ANGLE 

all 39053

08-03-17-146

NOTES:

- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.125
PER AMS-QQ-A-200/8
(REF. DART SPEC. M5081T6A750XW125) 
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 0.8 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

B	SHEET 1 NOTES DART SPEC. IN MATERIALS LIFOATED, ISO VIEW UPDATED, SHEET 2 ZONE C4, Ø0.001 HOLES WERE Ø0.155, ZONE 7B 0.446 DIM WAS 0.450.		AJS	08.03.06
A	NEW ISSUE		AJS	08.01.31
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	<i>LE</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>SS</i>	D3730	SHEET 1 OF 2	
APPROVED	<i>AP</i>	TITLE	SCALE	
DE APPR.	<i>AP</i>	ANGLE	NTS	
DATE	08.03.06	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT FOR PUBLIC RELEASE. IT IS LOANED TO YOU FOR YOUR INFORMATION ONLY. IT IS NOT TO BE USED FOR ANY PURPOSE, REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>		

DART AEROSPACE LTD		Work Order: 39053
Description: ANGLE		Part Number: D 37301
Inspection Dwg: D3730 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.159	+ .004 / - .001	0.161	✓			
Ø 0.098	+ .004 / - .001	0.099	✓			
0.375	+/- .010	0.370	✓			
0.625	+/- .010	0.620	✓			
1.250	+/- .010	1.250	✓			
2.00	+/- .030	2.001	✓			
0.440	+/- .010	0.440	✓			
0.13	+/- .030	0.130	✓			
0.75	+/- .030	0.756	✓			
0.13	+/- .030	0.130	✓			
0.75	+/- .030	0.756	✓			
R 0.13	+/- .030					grind manually

Measured by: M.A./mx	Audited by: S	Prototype Approval:
Date: 08/05/06	Date: 08/05/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	